

Date: Thursday, 05/06/2008 8:49:26 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 39716
 Estimate Number : 12734
 P.O. Number :
 This Issue : 05/06/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D353525
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3535 REV B
 Previous Run : 38867 Project Number : N/A
 Material :
 Due Date : 12/06/2008 Qty: 30 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-02-15 JLM
 Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.5355 sf(s)/Unit Total : 16.0650 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 108156 HB 8-6-9

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B HB 8-6-9
 Prog Rev: B

2-Deburr if necessary HB 8-6-9

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326
 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 8:49:26 AM
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Drawing Name: WEARSHOE

Job Number: 39716

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Wente
S 08/06/12 *(X39)*

7.0

POWDER COATING

POWDER COATING



M1105642



(39X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

1:00 pm

OVEN TEMPERATURE:

320 °F

FINISH TIME:

1:30 P.m

m-l 08/06/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/06/12 *(39)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F P-17

m-l 08/06/12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/13

Job Completion



MF 08-06-13

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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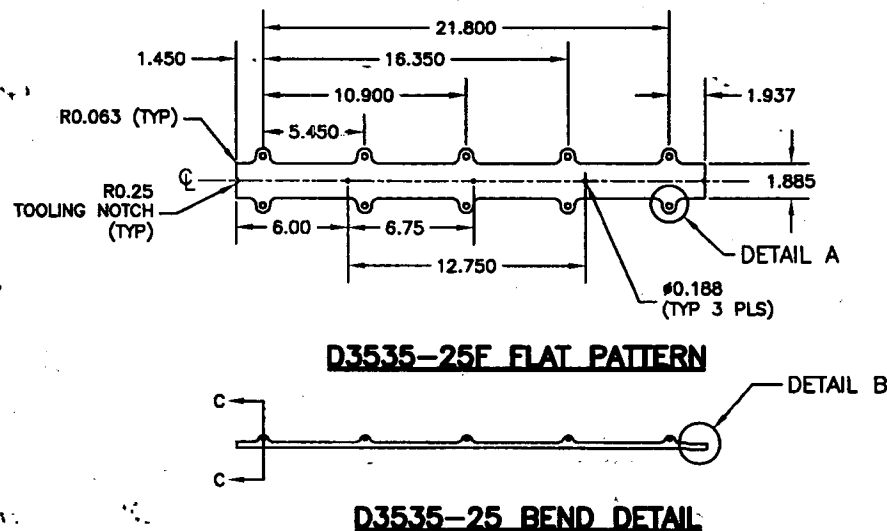
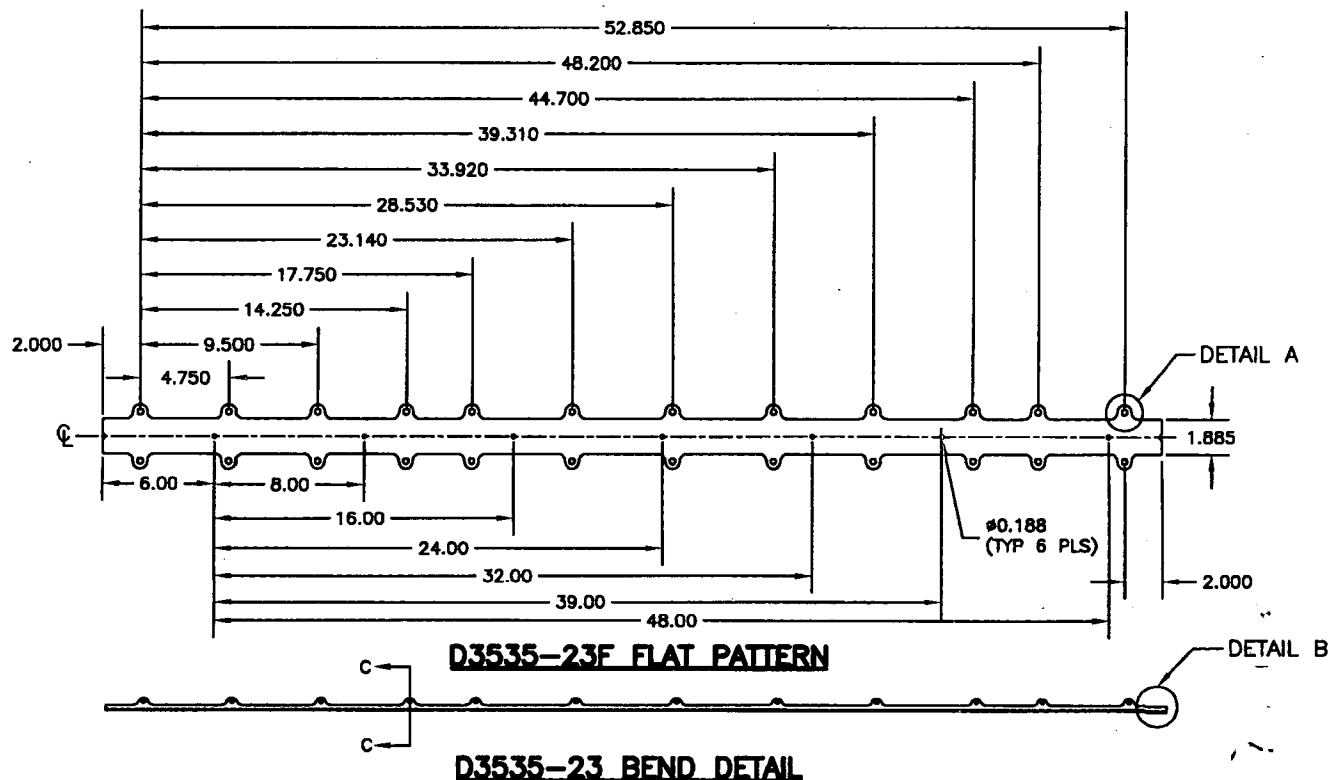
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DART

RELEASED

07.04.24



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	3 OF 7	SCALE

Dart Aerospace Ltd

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QA: N/C Closed: _____ Date: _____

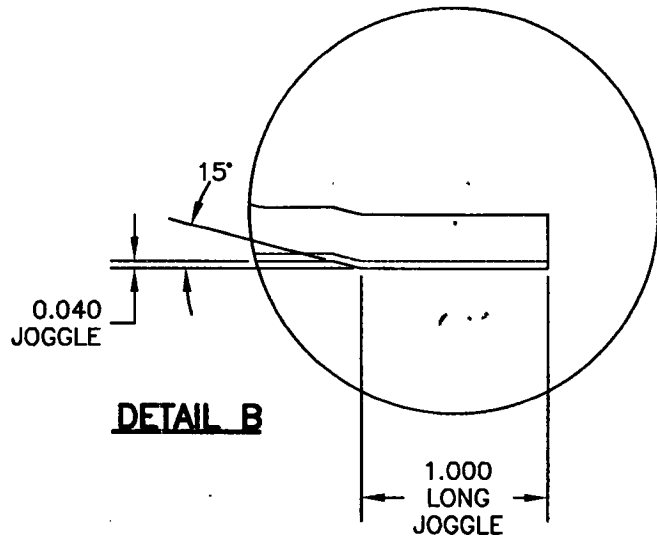
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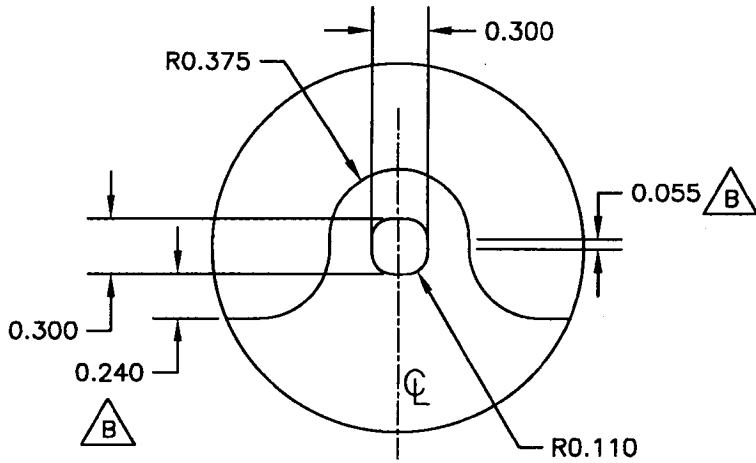


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 7 OF 7	SCALE 1:1

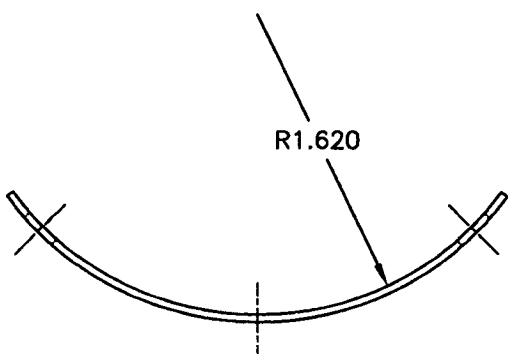
RELEASED
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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